

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020111**Date Inspected:** 08-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ming Yang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3020-AZ

Weld No: 013

B-WR: 18621

Welder: 045246

WPS-345-SMAW-1G(1F)-Repair

PCMK: SEG-3020-AZ

Weld No: 008

B-WR: 18622

Welder: 051348

WPS-345-SMAW-1G(1F)-Repair

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PCMK: SEG-3014-G

Weld No: 126

B-WR: 18531

Welder: 066258

WPS-345-SMAW-3G(3F)-Repair

PCMK: SEG-3014-G

Weld No: 114

B-WR: 18532

Welder: 066258

WPS-345-SMAW-3G(3F)-Repair

PCMK: SEG-3014-J

Weld No: 062

B-WR: 18542

Welder: 045213

WPS-345-SMAW-3G(3F)-Repair

PCMK: SEG-3014-J

Weld No: 067

B-WR: 18543

Welder: 045213

WPS-345-SMAW-3G(3F)-Repair

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Fluxed Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ming Yang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3014-C

Weld No: 126

B-WR: 18504

Welder: 045143

WPS-345-FCAW-3G(3F)-Repair

PCMK: SEG-3014-C

Weld No: 122

B-WR: 18505

Welder: 045143

WPS-345-FCAW-3G(3F)-Repair

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PCMK: SEG-3014-C

Weld No: 114

B-WR: 18506

Welder: 201583

WPS-345-FCAW-3G(3F)-Repair

PCMK: SEG-3014-C

Weld No: 106

B-WR: 18508

Welder: 201583

WPS-345-FCAW-3G(3F)-Repair

PCMK: SEG-3014-C

Weld No: 206, 207

Welder: 068445

WPS-B-T-2232-ESAB

PCMK: SEG-3014-C

Weld No: 213, 214

Welder: 068445

WPS-B-T-2233-ESAB

PCMK: SEG-3014-C

Weld No: 161, 163, 169, 167, 165

Welder: 066421

WPS-B-T-2232-ESAB

PCMK: SEG-3014-C

Weld No: 166, 164, 168, 162, 170

Welder: 066421

WPS-B-T-2233-ESAB

PCMK: DP-3118-001

Weld No: 107, 108

Welder: 204730

WPS-B-T-2233-ESAB

PCMK: DP-3118-001

Weld No: 078, 100

Welder: 048696

WPS-B-T-2233-ESAB

PCMK: DP-3119-001

Weld No: 126, 127

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Welder: 048433
WPS-B-T-2233-ESAB

PCMK: DP-3119-001
Weld No: 095, 101
Welder: 203871
WPS-B-T-2233-ESAB

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Photos please see ; Z:\Inspector Reports\B314 Rice

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
